

Work Order ID 105870

105870

Page 1

August-23-13 7:49:27 AM

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft, Out
 Start Date: 8/23/13 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 9/06/13 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-08-23 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2573	F

100 HAAS CNC VERTICAL MACHINING #1 0.00
100
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Program Batch No. BT
 Double check by: [Signature]
 Jfc 2013-09-13 10
 / BT 13-09-14

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

110 CONVENTIONAL MILLING MACHINE 0.00
110
 Mill Conv Memo 0.00
 Conventional Milling Machine Machine keyway as per dwg D2573 & D2574
 Jfc 2013-09-13 10
 / BT 13-09-14

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August-23-13 7:49:27 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 8/23/13 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 9/06/13 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

120

Memo

0.00

QC

Quality Control

Ofe / 2013-09-13
13-09-14

12

0.00

130

Memo

0.00

QC

Quality Control

on 13/09/16

10

~~_____~~

0.00

140

Memo

0.00

HandFinish

Hand Finishing

12

13.09.16

Work Order ID 105870***105870***

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August-23-13 7:49:27 AM

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, Out
Start Date: 8/23/13 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 9/06/13 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MC 13-09-18

13-09-10

Picklist Print

Page 1

August-23-13 7:49:31 AM

Work Order ID: 105870

105870

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft, Out

Start Date: 8/23/13

Required Date: 9/06/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007

Manufactured

No

100

Each

75.0000

1

12

**

45 13-09-11

D6101-007

Saddle Billet

Location

Loc Qty

Loc Code

MAT041

20

92730

20

MAT042

30

103030

30

MAT044

25

102215

14

105096

11

DART AEROSPACE LTD	Work Order: 105870
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.006	8.006	8.005	8.005		
F	0.490	0.510		0.505	0.504	0.503	0.504		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.501	0.504	0.504	0.506		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.567	0.568	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.129	0.128	0.127	0.127		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.258	0.258	0.258	0.257		
S	0.115	0.135		0.129	0.128	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.235	0.236	0.237	0.234		
W	0.115	0.135		0.131	0.130	0.130	0.130		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.358	0.362	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.627	0.629	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.246	0.247		
AE	1.500	1.520		1.515	1.515	1.514	1.514		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.249	0.250	0.250		
AI	2.000	2.020		2.006	2.005	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: JFC / JT	Audited by: [Signature]
Date: 2013-09-12	Date: 13/09/13

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]

DART AEROSPACE LTD		Work Order:	105870
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	25	26	27	28	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.503	0.506	0.504	0.506		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.505	0.505	0.503	0.504		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.571	0.572		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.127	0.127	0.126	0.126		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.257	0.259	0.256	0.256		
S	0.115	0.135		0.127	0.128	0.128	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.236	0.231	0.235	0.240		
W	0.115	0.135		0.130	0.130	0.130	0.130		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.361	0.361	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.626	0.629	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.243	0.246	0.246		
AE	1.500	1.520		1.516	1.517	1.517	1.513		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.246	0.246	0.251		
AI	2.000	2.020		2.0035	2.006	2.005	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	JFC
Date:	2013-09-13

Audited by:	[Signature]
Date:	13/09/16

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]

DART AEROSPACE LTD		Work Order: 105870
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

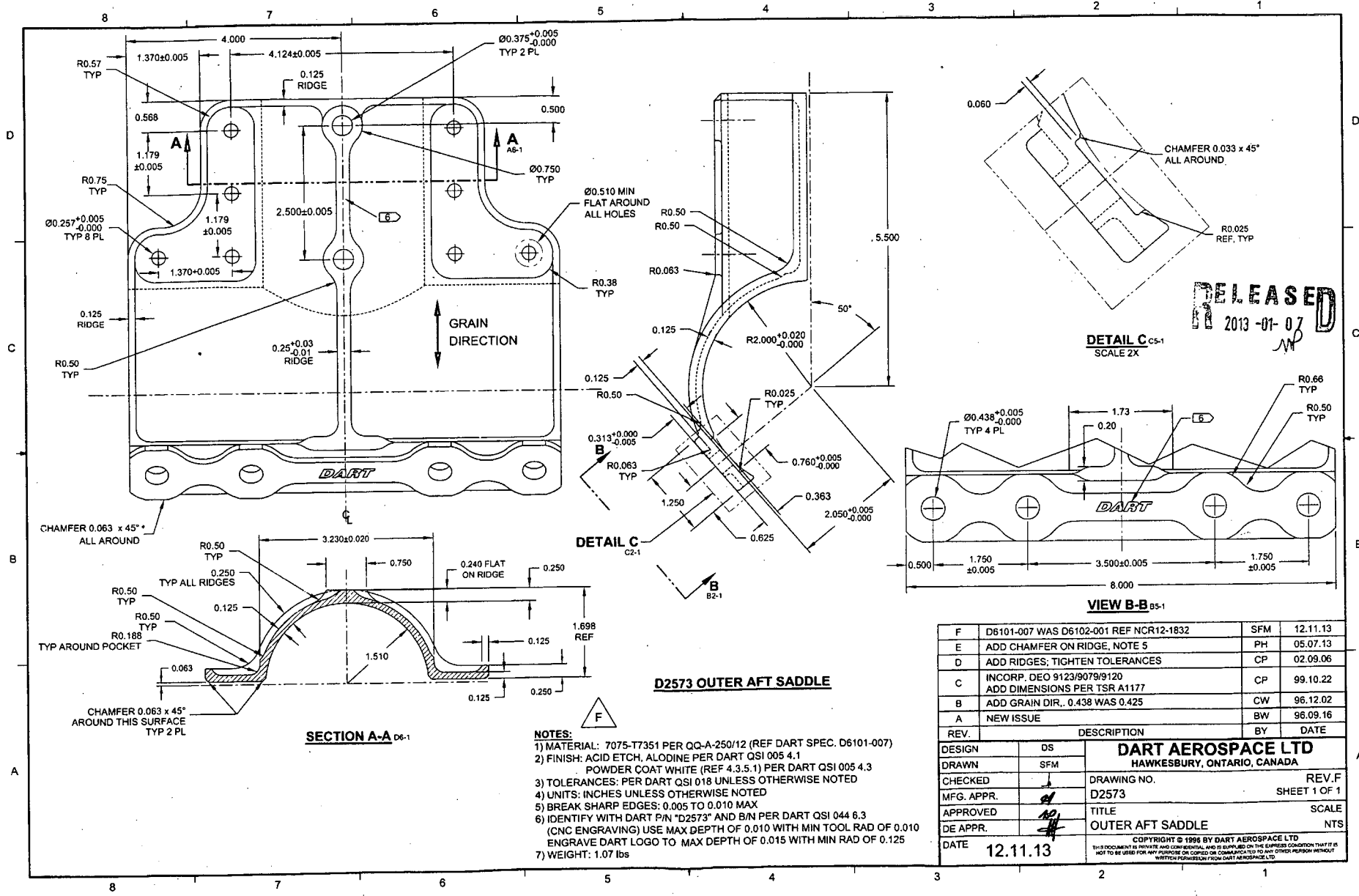
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.005	8.001				
F	0.490	0.510		.506	.500				
G	0.257	0.262		.260	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.503	.505				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.571	.572				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.126	.127				
Q	0.115	0.135		.125	.125				
R	0.240	0.260		.256	.256				
S	0.115	0.135		.130	.127				
T	0.178	0.198		.188	.186				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.239	.239				
W	0.115	0.135		.130	.131				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.362	.362				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.628	.626				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.246	.246				
AE	1.500	1.520		1.514	1.516				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.252	.251				
AI	2.000	2.020		2.004	2.006				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	ST
Date:	13-09-14

Audited by:	[Signature]
Date:	13/09/14

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]



RELEASED
2013-01-07

F	D6101-007 WAS D6102-001 REF NCR12-1832	SFM	12.11.13
E	ADD CHAMFER ON RIDGE, NOTE 5	PH	05.07.13
D	ADD RIDGES; TIGHTEN TOLERANCES	CP	02.09.06
C	INCRP. DEO 9123/9079/9120 ADD DIMENSIONS PER TSR A1177	CP	99.10.22
B	ADD GRAIN DIR., 0.438 WAS 0.425	CW	96.12.02
A	NEW ISSUE	BW	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV.F
MFG. APPR.		D2573	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		OUTER AFT SADDLE	NTS
DATE	12.11.13	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

105870-MCS
13-08-23

